

### ABSTRACT OF THE DISCLOSURE

A toner of the invention includes toner particles comprising a styrene acrylate binder and at least one colorant, and wherein the toner particles, in the absence of external additives, have a mean circularity of from about 0.94 to about 0.98 and a particle size distribution with a lower number ratio geometric standard deviation (GSD) of approximately 1.28 to approximately 1.31 and an upper volume GSD of approximately 1.24 to approximately 1.27. Also included is a set of toners for forming a color image, comprising a cyan toner, a magenta toner, a yellow toner and a black toner, wherein each of the cyan toner, the magenta toner, the yellow toner and the black toner have toner particles of about 70 to about 95% by weight, dry basis, of a styrene acrylate binder, about 5 to about 15% by weight, dry basis, of a wax dispersion, and at least one colorant.